Selectarc Fonte Ni2

Pure Nickel Electrode

Classification

AWS A 5.15 : ENi-CI
ISO 1071 : E C Ni-CI 3
DIN 8573 : E Ni BG 12

Description & Applications

Electrode with graphite-basic coating to weld on DC - and AC. Weld deposit consists of pure nickel. Recommended for cold welding and repairing of grey cast iron, repairing of cracks. Homogeneous and easy to machine deposit. Good bonding and flow of the weld metal.

Main applications: Repairing of engine blocks, frames of tool machines, gearboxes, reducing pieces, valve and pump bodies.

Base materials

Grey cast iron to different steels :

ASTM	DIN	NFA
A48 Class 25B – A48 Class 60B	GG-15 to GG-40	FGL 150 to FGL 400

Typical Weld Metal Composition (%)

C	Si	Fe	Ni
1.0	<1.2	<2.0	>95

All Weld Metal Mechanical Properties

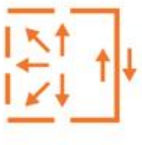
R_m (MPa)	Hardness
>300	Approx. 180 HB

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x350
Current	(A)	80	120	150

Weld on clean and exempt from grease surfaces (previous grinding of the joint). Apply a heat input as low as possible and keep the temperature low (< 70°C). Weld with lowest practical current and depose short and narrow beads to reduce the risk of producing cracks in the base metal. To reduce stresses, produced during welding, hammering of the beads is recommended after the deposition of short runs (essential on rigid pieces).

ind.12



= -	~ 40 V

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